

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007603**Date Inspected:** 15-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 2:

1AAE

This Caltrans QA inspector monitored activities related to end and strand stiffener replacement for Partial Joint Penetration (PJP) welds exceeding Welding Procedure Specification root gap tolerance on OBG segments 1AAW and 1AAE.

The following base excavation areas that were tested and accepted by ZPMC MT technicians were verified and by Caltrans QA.

The following base metal excavation repair areas that were tested and accepted by ZPMC MT technicians were verified and accepted by QA.

A13 - SEG 2E-429, 387, 347, 305  
SEG 2D-129, 130, 184

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A21- SEG 2E- 355, 313

SEG 1C- 148

A26- SEG2E-150, 109, 190, 240

SEG2C-045, 046

A27- SEG2E-319, 361, 151, 241

SEG2C-130, 041

FCAW welding of weld joint SEG2F-027, SEG2E-416 1AAE stiffener welds at location A00. ZPMC welder was identified as 201583. ZPMC QC is identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2233-TC-U4b-F.

FCAW welding of weld joint SEG2E-402, SEG2E-444 1AAE and SEG2C-126 stiffener welds at location A28. ZPMC welder was identified as 201583. ZPMC QC is identified as Chen Xi. The welding appeared to be in conformance with welding procedure specifications, WPS-B-T-2233-TC-U4b-F and WPS-B-T-2132-3.

The following stiffener welds that were tested and accepted by ZPMC MT technicians were verified and accepted by QA.

A41- SEG2E-333, 214

SEG2F-001, 005

SEG2C-002, 086

Joint Fit-up of stiffeners verified by ZPMC ABF and CT:

1. Weld joints SEG2E-137, 227, SEG2D-044 located at location A13
2. Weld joints SEG2E-383, 343, SEG2D-116 located at location A9
3. Weld joints SEG2E-111, 192, SEG2C-149 located at location A28

FCAW welding of weld joint SEG2F-027, SEG2E-416 1AAE stiffener welds at location A00. ZPMC welder was identified as 201583. ZPMC QC is identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2233-TC-U4b-F.

FCAW welding of weld joint SEG2E-402, SEG2E-444 1AAE and SEG2C-126 stiffener welds at location A28. ZPMC welder was identified as 201583. ZPMC QC is identified as Chen Xi. The welding appeared to be in conformance with welding procedure specifications, WPS-B-T-2233-TC-U4b-F and WPS-B-T-2132-3.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

As identified within the contents of this report.

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### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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